

Date Thursday, 16/08/2007 10:23:01 AM  
User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG		
Job Number	: 33995		Part Number	: D27313		
Estimate Number	: 11019		Drawing Number	: D2731 REV B		
P.C. Number	: N/A		Project Number	: N/A		
This Issue	: 16/08/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 15/09/2007		
Previous Run	: 30994		Qty:	50	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est:D 00/05/19 Added inspect level 8, removed P/O for powder coating EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
	Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)	
	Lug Extrusion D2423	
	Batch: B33310 C207/08/20	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW	
	Cut D2423 Extrusion: 0.82" Long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		<i>Issue P.O</i> <i>4404 C207/08/20</i> <i>(50)</i>
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Machine as per folio D2731-3	
	Check for crack while loading into the machine	
	Tumble Deburr any rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>Rewire &amp; Inspect for transit damage</i> <i>(50)</i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC5	SECOND CHECK
		<i>QSP019</i> <i>(50)</i>
	Comment: SECOND CHECK Inspect level 5	
		<i>or as tag for +50</i> <i>(50)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">50X</span>
			<i>M/J</i> 07/09/06
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	POWDER COATING	POWDER COATING	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">50</span>
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>M 105088</i> <i>BL</i> 07-09-08
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">50X</span>
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<i>M/J</i> 07/09/06
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		<i>G/09/09/11</i> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">50</span>
10.0	QC21	FINAL INSPECTION/W/O RELEASE	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">50</span>
	Comment: FINAL INSPECTION/W/O RELEASE		<i>D 09/09/11</i>

Job Completion



*6/07/09/11*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

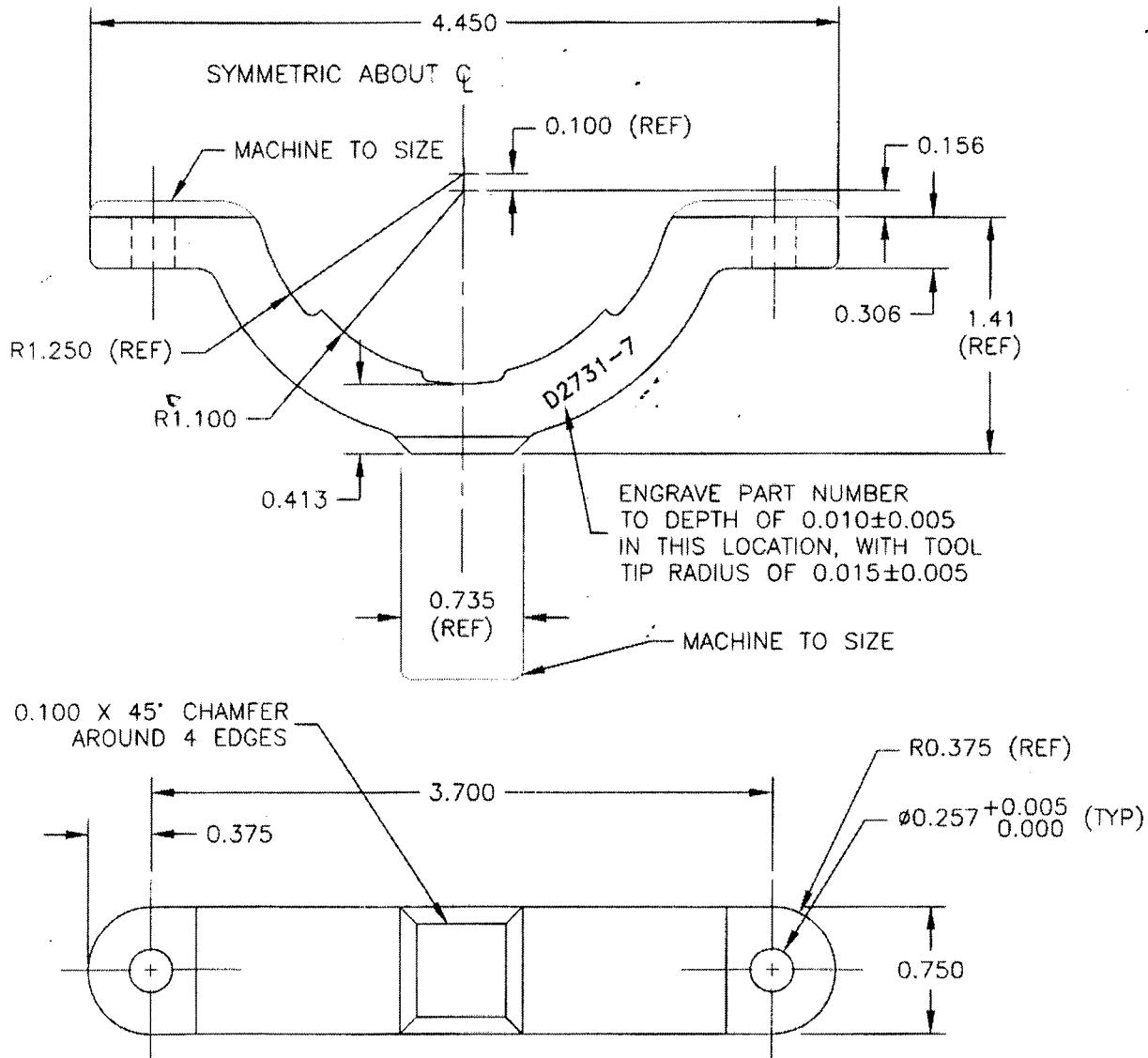
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>SD</i>	DRAWING NO. D2731
DATE 99.07.06		TITLE MOUNTING LUG

REV. B  
SHEET 4 OF 4  
SCALE  
1:1

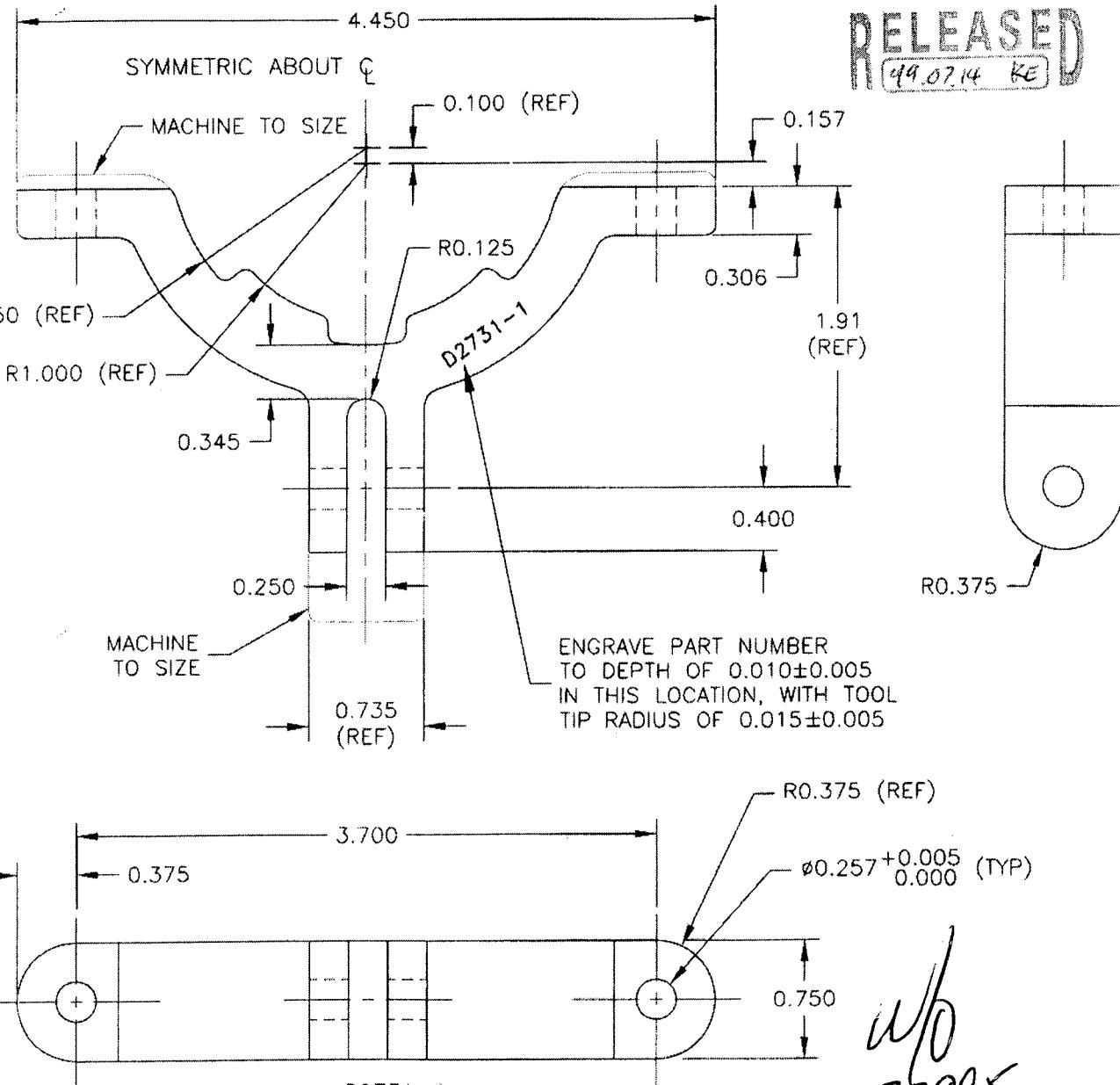
RELEASED  
99.07.14 KE



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JX</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 1 OF 4
		TITLE MOUNTING LUG
A	98.05.13	SCALE 1:1
B	99.07.06	REVISED DIMENSIONS

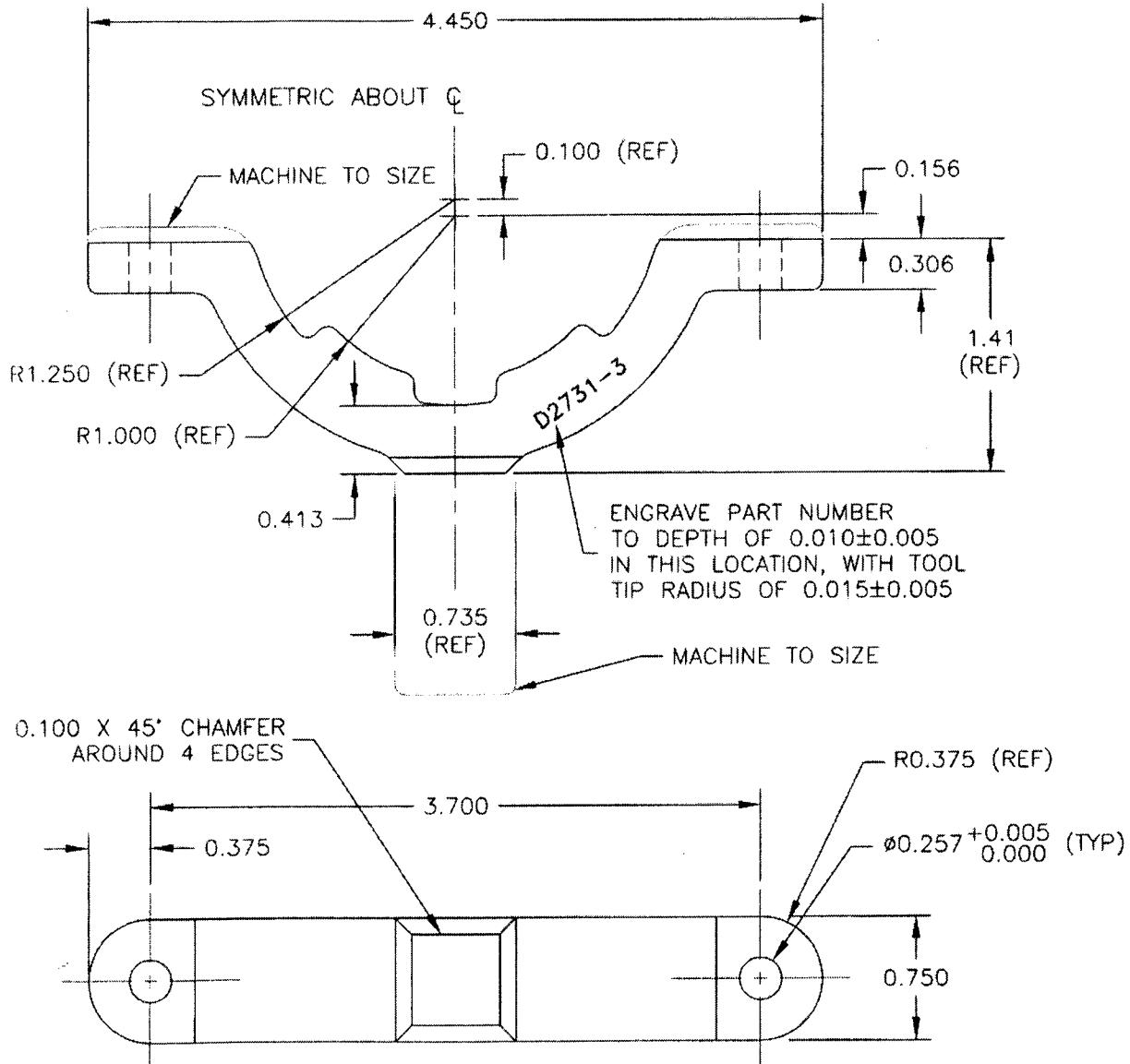


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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JF</i>	DRAWING NO. D2731
DATE 99.07.06		REV. B SHEET 2 OF 4 TITLE MOUNTING LUG SCALE 1:1

RELEASED  
1999.07.14 KE

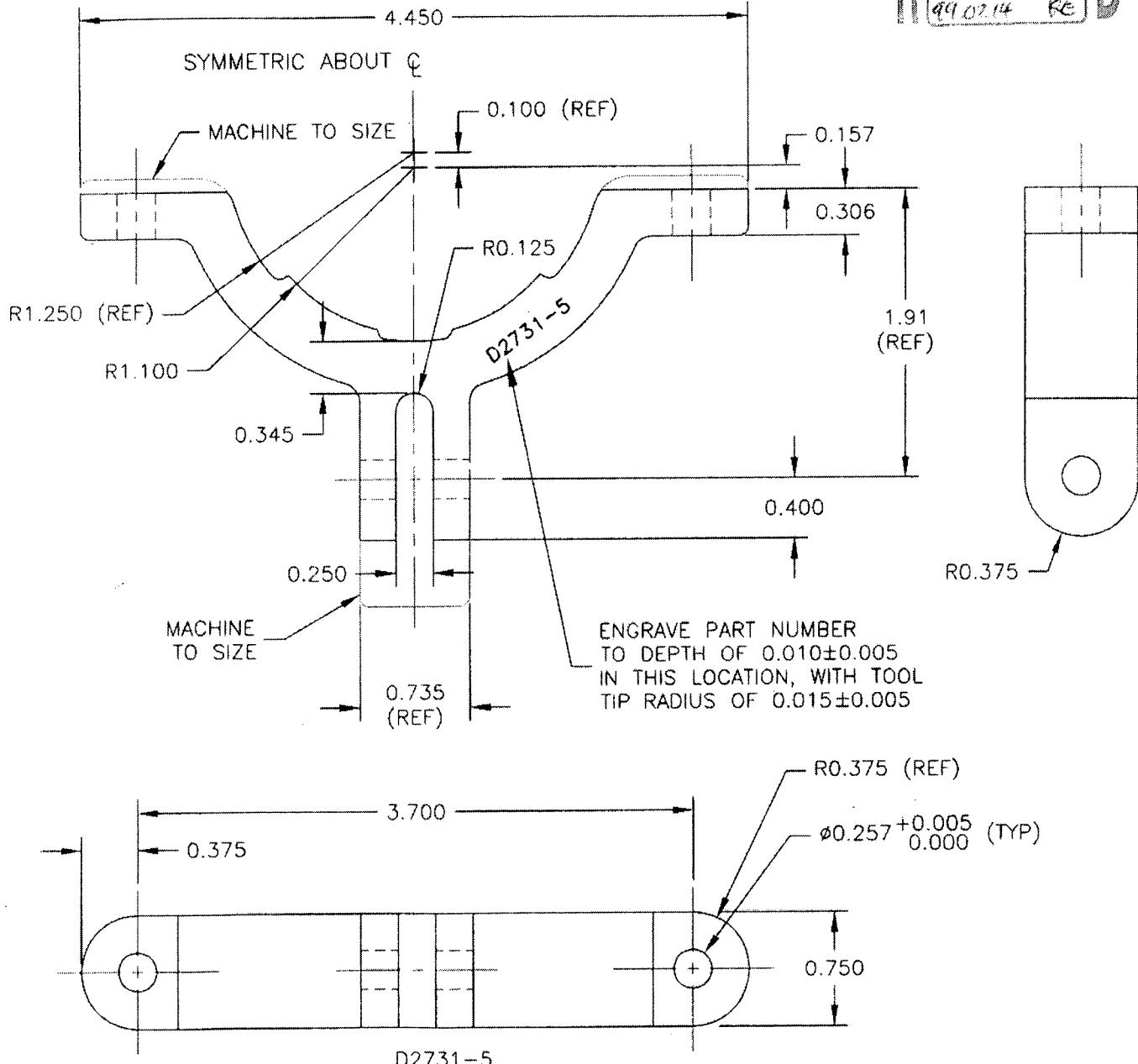


MAKE FROM EXTRUSION D2423  
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2731
DATE 99.07.06	TITLE MOUNTING LUG	REV. B SHEET 3 OF 4 SCALE 1:1

RELEASED  
99.07.14 *KE*



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000–0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



## CERTIFICATE OF CONFORMITY

**SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3414-3	Lug Assembly MATERIAL: supplied by DART	4404
50	D2731-3	Lug MATERIAL: supplied by DART D2423 B33310	4404

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig-Walz".

Vankleek Hill, August 31, 2007

